

Work Order ID 117295

June-05-14 2:30:41 PM

117295

u/AS
~~PRELIMINARY ISSUE~~

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Item ID: D4894-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam
 Start Date: 6/05/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference: rework

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4894	A

105

0.00

105

Small Fab

Small Fab

Memo

0.00

PULL FROM STK:
 1 X D4894-3 B109295
 1 X D4894-3 B103336

COUNTERSINK BOTH SIDES PER ATTACHED DRWG - DEBURR

RIVET MS20426AD4-X *8/1129494*
 PER ATTACHED DRWG

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Quality Control

Memo

0.00

*DAS
27
9-89
4/6/16*

2x

14/06/16

DAS
36
9-89

*P/O
→*

2

RQA:

AW

Date:

14/07/11

QA Closed:

AW

Date:

14-6-27

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐Work Order: 117295Part No. 104894-3NCR No. 14-3980

DISPOSITION

 Rework ☒
 Scrap ☐
 Use-as-is ☐
 Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input checked="" type="checkbox"/>				Custom work performed on Part.					
Doc/Data <input checked="" type="checkbox"/>				see NCR on Attach					
Equip/Tooling <input type="checkbox"/>				DRAWING					
Handling/Pre <input type="checkbox"/>				Re. Design change					
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☒ Other
Design change

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
141 *141* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>11/12/07</i> Memo <i>As 14-6-16</i> SCUFF A/R RE-POWDERCOAT PER QSI005 MASK AS PER NOTE 8	0.00 <i>START: 12:40.</i> 0.00 <i>OVER T: 3200</i> <i>FINISH 7:10.</i>				<i>2</i>	<i>6</i>	<i>H-6-K.</i>	
142 *142* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>SH</i> 0.00 <i>14/6/16</i>				<i>2</i>			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>ST---</i> RE-IDENTIFY USING NEW B/N	0.00 0.00						<i>2 17/9/16</i>	<i>Lu</i>

Picklist Print

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Parent Item: D4894-3

D4894-3

Parent Item Name: Aft Beam

Start Date: 6/05/14

Required Date: 6/05/14

Start Qty: 2.00

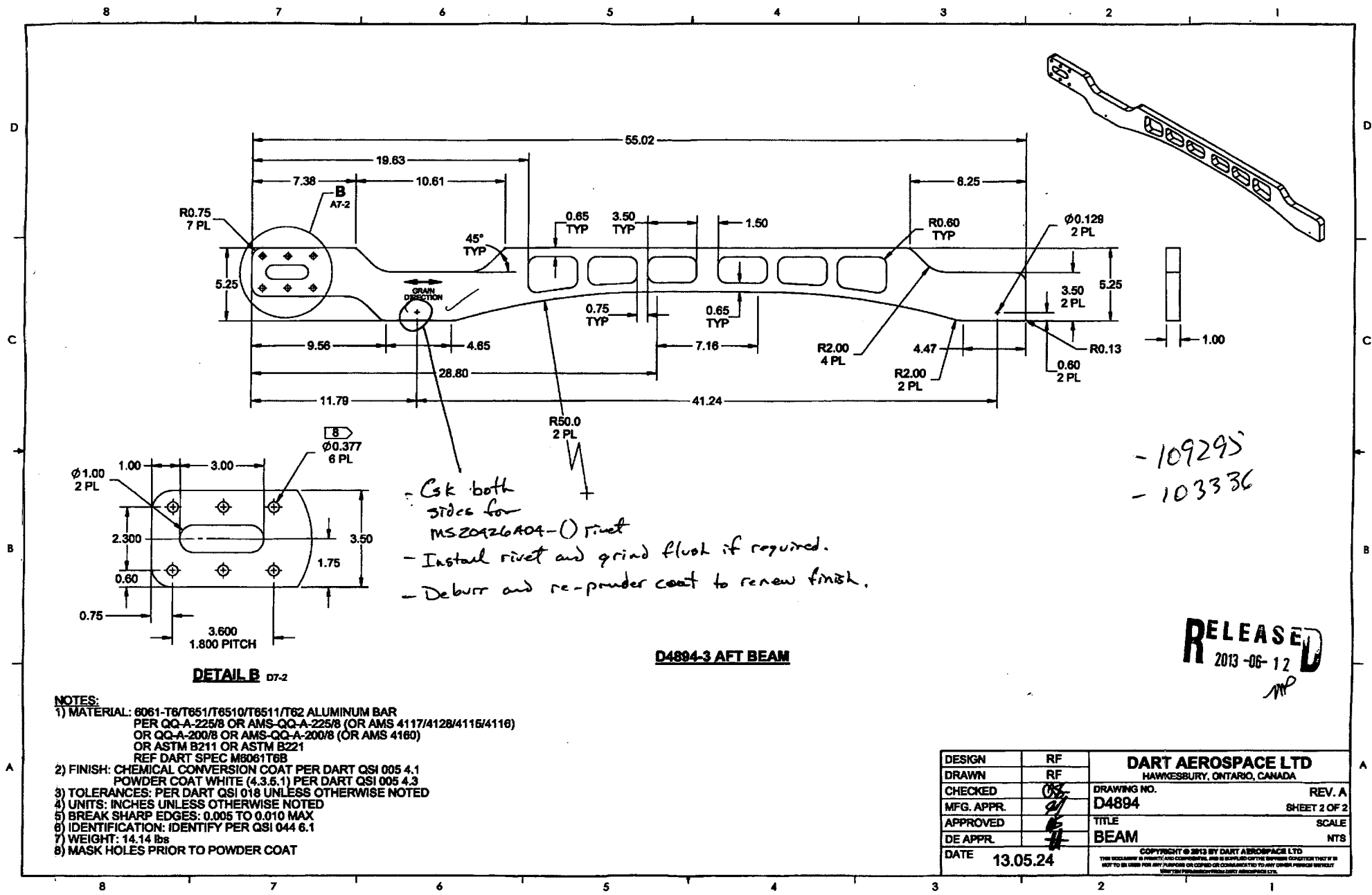
Required Qty: 2.00

Comments: IPP REV:B 13.05.27 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4894-3 *D4894-3* Aft Beam		Manufactured	No				Each	0.0000		2		14/06/16	DAS 36 989

B103336 **
(2x)

117295



- 109295
- 103336

RELEASED
2013-06-12
MP

D4894-3 AFT BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 14.14 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	08	DRAWING NO.	REV. A
MFG. APPR.	21	D4894	SHEET 2 OF 2
APPROVED	5	TITLE	SCALE
DE APPR.	11	BEAM	NTS
DATE	13.05.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS PROGRAM IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

pull
compare to both sides
per day

rivet one piece

powder coat.

Linda Lacelle

From: Roberto Fuentes
Sent: June-12-14 1:08 PM
To: Harvey Siemens; Linda Lacelle
Cc: Mike Petsche
Subject: RE: D4894 Rev. A now Under Review

Hi Linda,

Am sending to you attention (qty 10) MS20426AD4-20 rivets Ref. Eagle Bin# LT-13-000400 today. If these are too long, they can trim as required to install properly ensure the D4894-3 get c 'sink both ends of the hole, grind flush as per mark up drawing sent to David Duval last week.

Roberto

From: Harvey Siemens
Sent: June-12-14 8:28 AM
To: Linda Lacelle; Roberto Fuentes
Cc: Mike Petsche
Subject: RE: D4894 Rev. A now Under Review

Roberto,

Can you come up with the best guess for the long rivets that you need.

Regards,

Harvey

From: Linda Lacelle
Sent: June-12-14 8:26 AM
To: Harvey Siemens; Roberto Fuentes
Cc: Mike Petsche
Subject: RE: D4894 Rev. A now Under Review

Can you just let me know what rivets should be used, I'll see if I can get them here tomorrow...

From: Harvey Siemens
Sent: June-12-14 10:25 AM
To: Linda Lacelle; Roberto Fuentes
Cc: Mike Petsche
Subject: RE: D4894 Rev. A now Under Review

Linda,

I could send you some long ones if you want?

Regards,

Harvey

From: Linda Lacelle
Sent: June-12-14 8:06 AM
To: Roberto Fuentes
Cc: Harvey Siemens; Mike Petsche
Subject: RE: D4894 Rev. A now Under Review
Importance: High

We have no rivets long enough in alum to plug this hole...what do you suggest? We need to ship this tomorrow (or Monday, at this point)

LL

From: Roberto Fuentes
Sent: June-05-14 1:16 PM
To: David Duval; David Shepherd; Kim Johnston; Linda Lacelle; Melanie Fauteux; Mike Petsche; Nigel Forbes; Patrick Smith
Cc: Alan Stocker; Alex Pharand; Brigitte Golden; Chris Provencal; Daniel Campbell; David Bain; Eric Downing; Harvey Siemens; Jean Francois Sauve; Jean-Luc Menard; Regis Quenneville; Sian Willems; Victoria Seib; David Westbrook; Marc Bellavance; Mario Poulin
Subject: RE: D4894 Rev. A now Under Review

Sorry I push the wrong icon. The is drawing attach.

Roberto

From: Roberto Fuentes
Sent: June-05-14 11:13 AM

To: David Duval; David Shepherd; Kim Johnston; Linda Lacelle; Melanie Fauteux; Mike Petsche; Nigel Forbes; Patrick Smith

Cc: Alan Stocker; Alex Pharand; Brigitte Golden; Chris Provencal; Daniel Campbell; David Bain; Eric Downing; Harvey Siemens; Jean Francois Sauve; Jean-Luc Menard; Regis Quenneville; Sian Willems; Victoria Seib; David Westbrook; Marc Bellavance; Mario Poulin

Subject: D4894 Rev. A now Under Review